

Date: Friday, 10/13/2006 9:30:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 28968
 Estimate Number : 12462
 P.O. Number :
 This Issue : 10/13/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D35083
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3508 REV A
 Previous Run : 27711 Drawing Revision : A
 Material :
 Due Date : 10/30/2006 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 06 10 13
 Comment : Est Rev: A New Issue 06-06-20 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.7707 sf(s)/Unit Total : 9.2484 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S20GA)
 Batch: 1101463

SEALED per DH

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: A
 Prog Rev: Per L

SAD 06:10:21 12

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 06:10:21

12

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06:10:25 12

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508
 2-Form joggle as per Dwg D3508 Using DT8158

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPLATE

Job Number: 28968

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 57.03.13

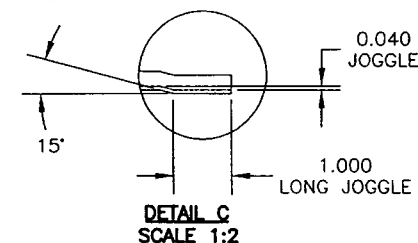
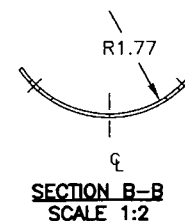
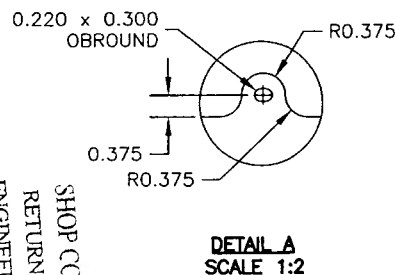
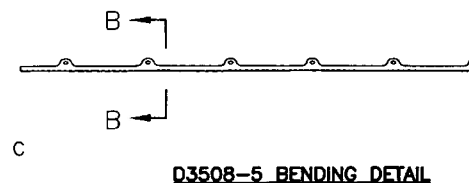
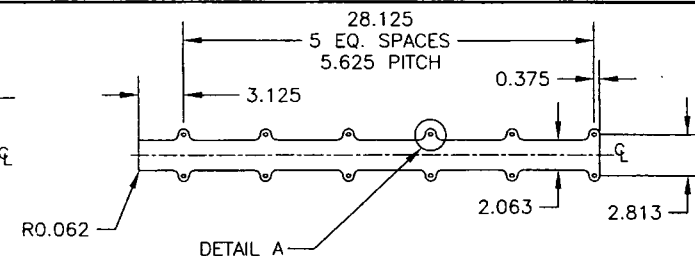
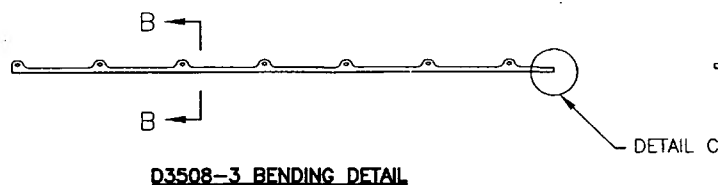
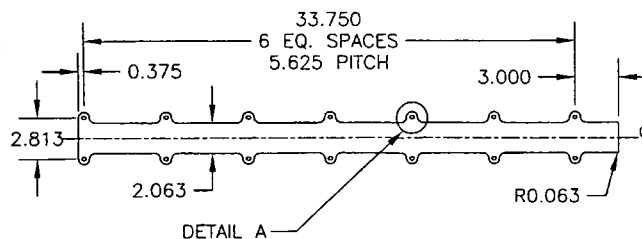
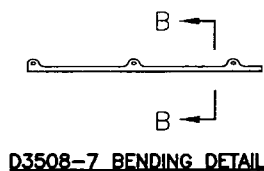
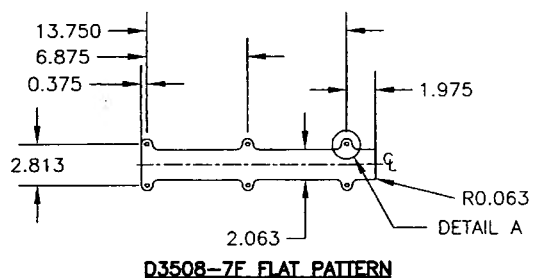
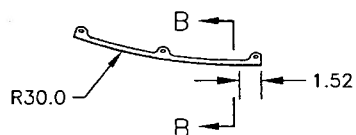
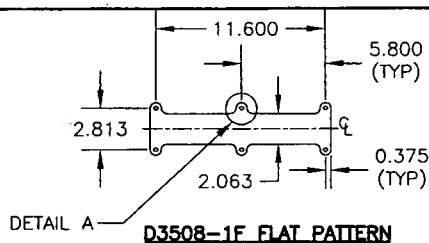
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

NO. 20868
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
06-10-02-PA
FOR ECU #861

A		06.04.21	NEW ISSUE
DESIGN	PH	DRAWN BY	PH
CHECKED	PH	APPROVED	PH
DATE	06.04.21	DRAWING NO.	D3508
		TITLE	WEARPLATE
		REV. A	SHEET 1 OF 1
		SCALE	1:1

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PORT HADLOCK, WA

